



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5377-1
Job Sheet 185782



Part No: D5377-1

Job Qty: 8 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/2/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 16-01-08 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Waterjet - Flow - 1	8 pcs	11/16/18	11/16/18	0.00	4.65	Waterjet - Flow		<i>OK 18/11/03</i>
130	CNC Vertical Machining	8 pcs	11/16/18	11/16/18	0.62	20.51	HAAS1-2		<i>OK 2018-11-28</i>
140	QC	8 pcs	11/16/18	11/16/18	0.00	0.00	QC2 Machining-4		<i>OK 2018-11-28</i>
150	QC	8 pcs	11/16/18	11/16/18	0.00	0.00	QC8 Machining-4		<i>OK 18/11/28</i>
151	Packaging	8 pcs	11/16/18	11/16/18	0.00	0.00	Packaging3		<i>OK</i>
190	QC21-SA	8 Ea	11/16/18	11/16/18	0.00	0.00	QC21		<i>NOV 29 2018</i>

Part Op 120 - Cut Blank as per D5377-1_blank File

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per FolioFB448 and Dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black, - 48"x120" Tivar Mfg.#52480104	42.4000 sf (5.3 ea)	120-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Waterjet - Flow - 1	MUHMWB10	42	625	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.380Inches $\pm$ 0.030	0.410 0.350		
2	Bearpaw	5.000Inches $\pm$ 0.030	5.030 4.970		
3	Bearpaw	3.930Inches $\pm$ 0.030	3.960 3.900		
4	Bearpaw	1.380Inches $\pm$ 0.030	1.410 1.350		
5	Bearpaw	5.500Inches $\pm$ 0.030	5.530 5.470		
6	Bearpaw	1.720Inches $\pm$ 0.030	1.750 1.690		
7	Bearpaw	2.0Degrees $\pm$ 0.0	2.0		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

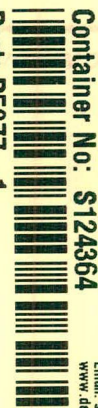
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																										
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			2.0	
8	Bearpaw	15.440Inches ± 0.030	15.470 15.410	
9	Bearpaw	4.688Inches ± 0.010	4.698 4.678	
10	Bearpaw	0.756Inches ± 0.010	0.766 0.746	
11	Bearpaw	0.700Inches ± 0.010	0.710 0.690	
12	Bearpaw	24.000Inches ± 0.030	24.030 23.970	
13	Bearpaw	21.340Inches ± 0.030	21.370 21.310	
14	Bearpaw	6.400Inches ± 0.030	6.430 6.370	
15	Bearpaw	3.520Inches ± 0.030	3.550 3.490	
16	Bearpaw	0.240Inches ± 0.030	0.270 0.210	
17	Bearpaw	0.250Inches ± 0.010	0.260 0.240	Radius
18	Bearpaw	0.300Inches ± 0.030	0.330 0.270	
19	Bearpaw	45.0Degrees ± 0.5	45.5 44.5	
20	Bearpaw	0.500Inches ± 0.030	0.530 0.470	
21	Bearpaw	0.740Inches ± 0.030	0.770 0.710	
22	Bearpaw	0.950Inches ± 0.030	0.980 0.920	
23	Bearpaw	0.261Inches + 0.006 - 0.001	0.267 0.260	
24	Bearpaw	0.500Inches ± 0.010	0.510 0.490	
25	Bearpaw	0.060Inches ± 0.030	0.090 0.030	
26	Bearpaw	45.0Degrees ± 0.5	45.5 44.5	
27	Bearpaw	0.460Inches ± 0.010	0.470 0.450	
28	Bearpaw	0.650Inches ± 0.010	0.660 0.640	
29	Bearpaw	0.375Inches ± 0.010	0.385	

Part: D5377-1
 Job No: 185782
 Serial No/Batch: S124364
 Revision:
 Inspector:
 Exp Date:
 Instructions: Various STC's

Date: 11/04/18



Container No: S124364

DART
AEROSPACE

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkebury, ON K6A 1K7
 CANADA
 TEL.: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

esse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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DART AEROSPACE LTD		Work Order:	
Description: Bearpaw		Part Number:	D5377-1
Inspection Dwg: D5377 Rev: A		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.38	+/-0.030	0.380	✓		Kt-05	vern
5.00	+/-0.030	5.000	✓			
3.93	+/-0.030	3.930	✓			
1.38	+/-0.030	1.380	✓			
5.50	+/-0.030	5.500	✓			
1.72	+/-0.030	1.720	✓			
2.00	+/-0.030	2.00	✓			
15.44	+/-0.030	15.44	✓		TAPE	
4.688	+/-0.010	4.688	✓		Kt-05	vern
0.756	+/-0.010	0.756	✓		"	"
0.700	+/-0.010	0.700	✓		"	"
24.00	+/-0.030	24.00	✓		TAPE	
21.34	+/-0.030	21.34	✓		"	"
6.40	+/-0.030	6.400	✓		Kt-05	vern
3.52	+/-0.030	3.52	✓		"	"
0.24	+/-0.030	0.248	✓		"	"
R0.250	+/-0.010	0.250	✓		D-G	
0.30 x 45°	+/-0.030 x +/-0.5°	0.300x45	✓		Kt-05	vern
0.50	+/-0.030	0.504	✓			
0.74	+/-0.030	0.735	✓			
0.95	+/-0.030	0.957	✓			
Ø0.261	+0.006/-0.001	0.261	✓			
0.500	+/-0.010	0.498	✓			
0.06 x 45°	+/-0.030 x +/-0.5°	0.050x45	✓			
0.460	+/-0.010	0.460	✓			
Ø0.650	+/-0.010	0.650	✓			
0.375	+/-0.010	0.375	✓			

Measured by: KJ	Checked by:	QC Inspector:
Date: 2018-11-27	Date:	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	16.03.30	New Issue	KJ	

